

Work Order ID 153752

Friday, November 25, 2016 7:42:30 AM

153752

Page 1

Item ID: D3204-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 11/28/2016 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: NOV 29 2016 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3204	Rev A1

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)								

DAS
44
9-89 16-12-18

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.36							
HAAS CNC vertical machine #1	1- Machine as per Folio FA344 and Dwg D32042- DeburrIdentify as D3204-5								

DAS
44
9-89 16-12-19

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
44
9-89 16-12-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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Page 2

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N900040100

Setup Start

NS1

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Stop

NS2

Item Name: Arm

Start Date: 11/28/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.02

Quality Control

8

0

DAS
20
9-89

16-12-19

140

Identify as per dwg & Stock Location: u/p 107

0.00

140

Packaging

Memo

0.01

Packaging

LOCATION : WA002

8

02/18/1-3

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.08

Quality Control

DAS
21
9-89

JAN 06 2017

DAS
21
9-89

JAN 03 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Picklist Print

Friday, November 25, 2016 7:42:30 AM

Page 1

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153752

Parent Item: D3204-5

D3204-5

Parent Item Name: Arm

Start Date: 11/28/2016

Required Date: 12/5/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.25 0		Purchased	No			100	f	18.5709	0.2913	1.533158			

M6061T6B0 375X01 250

6061-T6 Bar .375 x 1.25

DAS
44
9-89

16-12-18

Location

Loc Qty

Loc Code

MAT001

18.5709

M129530

18.5709

2.2571

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

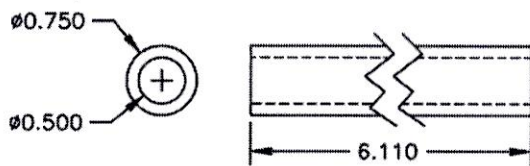
Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
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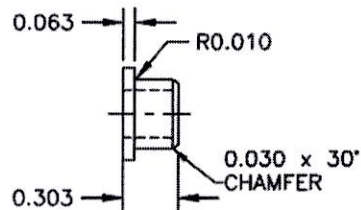
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DART

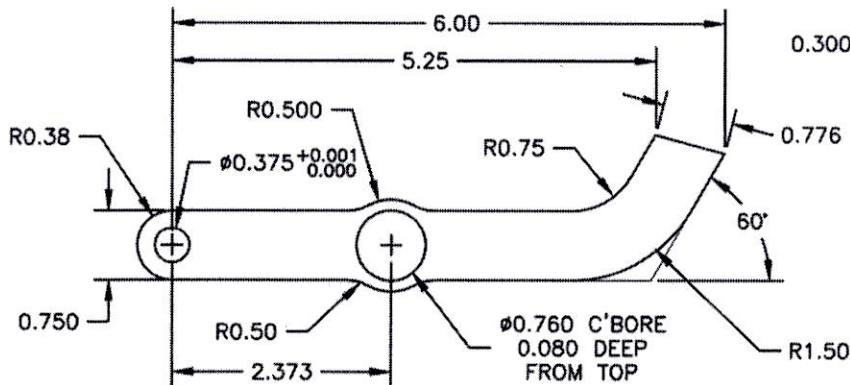
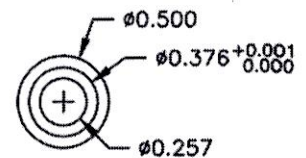
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CHECKED 	APPROVED 	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.05 

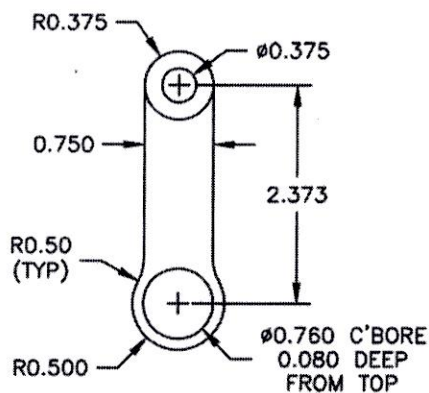
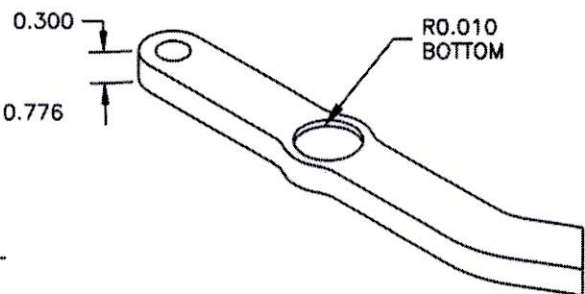
2 **D3204-1 TUBE**
SCALE 1:2



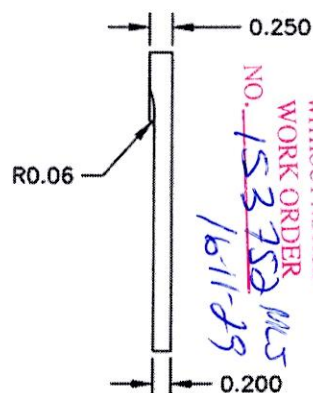
4 **D3204-7 BUSHING**
SCALE 1:1



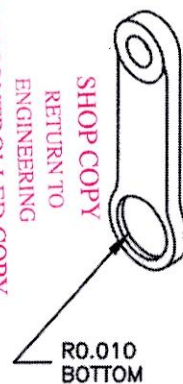
3 **D3204-3 ARM**
SCALE 1:2



3 **D3204-5 ARM**
SCALE 1:2



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153752 MLS
16-11-29

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